

Date: 5/25/2007 8:24:43 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE ASSEMBLY
 Job Number : 32617
 Estimate Number : 10022
 P.O. Number :
 This Issue : 5/25/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D205634011
 First Issue : 11 Type : LANDING GEAR Drawing Number : N/A
 Previous Run : 32616 Drawing Revision : N/A
 Written By : Due Date : 6/30/2007 Qty: 1 Um: Each
 Checked & Approved By : 07.05.28
 Comment : Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D205-634-011 CHG004

07.06.05

2.0 32617A SKID TUBE ASSEMBLY



Comment: Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B 32617A

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 K10003 D205-634-011 Saddle Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 K10003 Saddle Kit

1 D205-634-041 Skidtube Assembly(ref)

B31129

B32617A

5/27/08/010

5.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/8/11

SD

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:24:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE ASSEMBLY

Job Number: 32617

Part Number: D205634011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-011

Location: REV: J

[Signature]
07/08/01

7.0

QC21

FINAL INSPECTION/W/O RELEASE



07.08.02 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



[Signature]
07-08-01

32617A

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

26

Date: Friday, 5/25/2007 8:25:17 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY
Job Number : 32617A
Estimate Number : 10023
P.O. Number : N/A Part Number : D205634041
This Issue : 5/25/2007 S.O. No. : N/A Drawing Number : D2580 REV C
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : C
Previous Run : 32616A Material : N/A
Written By : Due Date : 6/30/2007 Qty: 1 Um: Each
Checked & Approved By : 07.05.28
Comment : Est Rev. N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
Est Rev. O 06.02.28 Added paperwork EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634 CHG001

N/A 07.05.28

2.0 D25001190 Ext'n -1' Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	B329602

507-6-18

3.0 D2596 205 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	B32652

507-6-18

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Inspect mat'l D2500-1-190 for damage
- 2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends
- 3-Acid etch and Alodine tube per QSI 005 4.1
- 4-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

507-6-18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:25:17 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32617A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 m103561

Sikaflex expire date: 7-10-1

Start Time: 8:00 Date: 7-6-18

Fin Time: 7:45 Date: 7-6-18

JD 7-6-18

5.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

EL 7-6-28

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends after cutting. Remove alodine from around holes

JD 7-7-11

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

p.m goes through all like
up 7/10/12 (+1)

8.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2576-3 Step B29486 BE07-07-12

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:25:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32617A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description:

20

D2579

Spacers

B32026

BE 07-07-12

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

BE 07-07-12

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m104721 BE 07-07-12

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m104721

BE 07-07-12

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

m104721

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

m07-07-180

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

m07-07-180

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

m07-07-180

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

m07-07-180

11.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

m07-07-20

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

m07-07-20

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

BL

07-07-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:25:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32617A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105 068

BR / FL 07-07-26

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1

07/07/27

16.0

D25771

Wearplate Fwd



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-1	Wearplate	B31212

FL

17.0

D25773

Wearplate Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-3	Wearplate	B30551

FL

18.0

D25775

Wearplate, Centre



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2577-5	Wearplate	B30812

FL

19.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
44	ALS7-1032-130	Inserts	B103495

FL 07/07/27



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:25:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32617A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

4 4

AN960JD10L

Washer

m/103641

FL

21.0

AN34A

Bolt



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

44

AN3-4A

Bolt

m/104817

FL

22.0

D25941

Plug



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

plug

Batch:

B32651

FL

23.0

D25943

O-Ring



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

o-ring

Batch:

B327168

FL

24.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B27488

FL

25.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch:

m/100188

FL 07/07/27

①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 07/08/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:25:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 32617A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch:

M103641

FL

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date: *08/01*

M104989

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date: *08/01*

M104989

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

M104942

Batch: *M104942*

M107-07-270

28.0

QC5

INSPECT WORK TO CURRENT STEP



Sp 07/30 (u)



All plugs in

tube

Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

PPP 32617

7/8/1 SD

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207108101

Job Completion



7/8/08.01

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. C SHEET 1 OF 2
DATE 98.08.26		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	

RELEASED
98/09/17 DS

QTY	Part Number	Description
X	D2580-041	SKIDTUBE ASSEMBLY
*	D2500-1	EXTRUSION
1	D2596	205 WEB
1	D2575	AFT CAP
1	D2576 - 3	STEP
20	D2579	CROSS BOLT SPACER
16	D2594-1	PLUG
16	D2594-3	O-RING
1	D2577-1	WEARSHOE
1	D2577-3	WEARSHOE
1	D2577-5	WEARSHOE
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or ALS4-1032-130	INSERT
46	AN3-4A	BOLT
46	AN960JD10L	WASHER

00.08.28
UP 00.08.28

EFFECTIVE DEOS
98/12/14
DEO 9124
DED 9/83

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES *
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3-4A BOLTS AND AN960JD10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

DETAIL B
SCALE 5:24

Ø 00.08.28
Ø 00.33.28

D2576-3

GRIND FLUSH (4 PLACES)

GRIND FLUSH

GRIND FLUSH

LOCATION RIDGE ON UNDERSIDE OF D2576

1/2

Technical drawing showing a detail of a bolted connection. The drawing includes the following labels and dimensions:

- #0.208**: Dimension indicating the diameter of the bolt.
- DRILL PRIOR TO D2575 CAP INSTALLATION (2 PLACES)**: Instruction for drilling holes before installing the cap.
- SEAL WITH SIKAFLEX-241**: Instruction for sealing the connection.
- AN3-4A BOLT (1)**: Specification for the bolt.
- AN96QD10L WASHER (1)**: Specification for the washer.
- (2 PLACES)**: Indication of the number of locations where the bolt and washer are used.
- D2575 CAP**: Specification for the cap.
- 0.40**: Dimension indicating the distance from the center of the bolt to the edge of the cap.

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

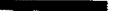
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

Elevation view of the bridge deck showing dimensions and reinforcement details:

- Top Left:** A box contains the dimension "37.50" above the text "DISTANCE TO AFT END OF DZ596 WEB". Below this are two triangles labeled "3" and "7".
- Reinforcement:** Two circular cross-sections of reinforcement bars are shown. The first bar has a diameter dimension of "Ø0.508 (TYP.) (40 PLACES)". An arrow points from the second bar to the note "REFER TO DETAIL A".
- Dimensions:**
 - A horizontal dimension of "38.0" spans from the left edge to the centerline.
 - A vertical dimension of "8.750" indicates the height of the deck at the first reinforcement location.
 - A horizontal dimension of "17.375" spans from the left edge to the centerline.
 - A horizontal dimension of "26.000" spans from the left edge to the centerline.
 - A horizontal dimension of "34.188" spans from the left edge to the centerline.
 - A horizontal dimension of "91.500" spans from the left edge to the right edge.
 - A horizontal dimension of "57.313 (REF)" spans from the centerline to the right edge, with the note "7 EQUAL SPACES 8.188 PITCH" below it.
 - A total horizontal dimension of "190.0 (DZ500-1)" spans the entire width of the deck.
- Other Labels:** "REFER TO DETAIL A" appears twice, pointing to the first reinforcement bar and the second reinforcement bar.

[illegible]

RELEASED
98/09/17 DS

DESIGN <i>DH</i>	DRAWN BY <i>CP</i>	 DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
CHECKED <i>DH</i>	APPROVED <i>JS</i>	
DRAWING NO. D2580		REV. C SHEET 2 OF 2
DATE 98.08.26	TITLE 205 SKIDTUBE ASSEMBLY SCALE 1:24	

NO. 116

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Barclay Elliott
Joint Welding Procedure Tig
Part number and Job number 205634C41/B32617A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skid tube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/01/06 Qualifier David A. Arenal